

Work Order ID 50902

July 24, 2009 10:19:59 AM



Page 1

Item ID: D3957-4
 Revision ID: A-PRELIM
 Item Name: Hinge, Door RH Lower
 Start Date: 24/07/2009 Start Qty: 2.00
 Required Date: 29/07/2009 Req'd Qty: 2.00
 Reference: *09.07.24*

Accept



Setup Start



Stop



PRELIMINARY ISSUE

Cust Item ID:
 Customer:



Run Start



Stop



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3957	A-PRELIM								

100

0.00



Bandsaw

0.00

Jeaspa Bandsaw

Memo

cut blank to 3.200" long

inf 09/07/24

2

110

0.00



HAAS 1

0.00

HAAS CNC vertical machine #1

Memo

1-Machine as per Folio FA839

FOLIO REV: *44*

DWG REV: *1*

88 09/07/27

2-FINISH TAPPING TO FULL DEPTH BY HAND AS PER DWG

3-DEBURR AS PER dWG



Work Order ID 50902




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Page 2

Item ID: D3957-4 Accept  Setup Start 
Revision ID: A-PRELIM Stop 
Item Name: Hinge, Door RH Lower
Start Date: 24/07/2009 Start Qty: 2.00  Cust Item ID:
Required Date: 29/07/2009 Req'd Qty: 2.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00							
			SF 09/07/27						
130  QC Quality Control	QC8- Inspect parts - second check ENGINEERING APPROVAL Memo	0.00 0.00							
			RA 09.07.28						
140  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo N/A	0.00 0.00							
			JUL 29 09-07-28						

1. The first step in the process is to identify the problem. This involves gathering information about the situation and the people involved.

2. The second step is to analyze the problem. This involves breaking the problem down into smaller parts and understanding the causes and effects.

3. The third step is to develop a plan. This involves deciding on the best way to solve the problem and setting goals and objectives.

4. The fourth step is to implement the plan. This involves putting the plan into action and monitoring progress.

5. The fifth step is to evaluate the results. This involves assessing the effectiveness of the solution and making adjustments if necessary.

July 24, 2009 10:19:59 AM

Accept

Setup	Start	Stop
1	2	3
4	5	6
7	8	9
10	11	12
13	14	15
16	17	18
19	20	21
22	23	24
25	26	27
28	29	30
31	32	33
34	35	36
37	38	39
40	41	42
43	44	45
46	47	48
49	50	51
52	53	54
55	56	57
58	59	60
61	62	63
64	65	66
67	68	69
70	71	72
73	74	75
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349	350	351
352	353	354
355	356	357
358	359	360
361	362	363
364	365	366
367		

[REDACTED]

Abstract

Start Date: 24/07/2009 **Start Qty:** 2.00
Required Date: 29/07/2009 **Req'd Qty:** 2.00

[illegible]

Cust Item ID:
Customer:

Reference:

Run	Start	Stop
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2	1	2
3	2	3
4	3	4
5	4	5
6	5	6
7	6	7
8	7	8
9	8	9
10	9	10
11	10	11
12	11	12
13	12	13
14	13	14
15	14	15
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94	93	94
95	94	95
96	95	96
97	96	97
98	97	98
99	98	99
100	99	100

Abstract

[REDACTED]

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
	Powdercoat	0.00							
	Powder Coating								
160	QC3- Inspect Part Finish	0.00							
	QC	0.00							
	Quality Control								
170	Identify as per dwg & Stock Location: _____	0.00							
	Packaging	0.00							
	Packaging								

Engineering Table
Change to
Remaining Eng. table
09-07-29



Work Order ID 50902


July 24, 2009 10:19:59 AM



Page 4

Item ID: D3957-4 Accept  Setup Start 
Revision ID: A-PRELIM Stop 
Item Name: Hinge, Door RH Lower
Start Date: 24/07/2009 Start Qty: 2.00  Cust Item ID:
Required Date: 29/07/2009 Req'd Qty: 2.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							

changed
to W/O.
RDO309A
JUL

POSITIVE RECALL

EFFECTIVE _____ AUTH _____
RELEASED _____ DATE _____

mf 09-07-29

Status	Item ID	Rev	Name	Quantity Per	UOM	Sort	Route Seq ID	Scrap %	Comments	Date Last Mod	Add Date
	M6061T6B0.750.		6061-T6 Bar .750 x 4.00	0.266666	f	1	100	5 %		22/07/2009 1...	22/07/2009

[Signature]

High 741

22/07/2009

533"

DART AEROSPACE LTD		Work Order: 50902
Description: 03957-4 Hinge		Part Number: 03957-4
Inspection Dwg: 03957 Rev: Prelim		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.56	±.03	.560	✓			
1.25	±.03	1.257	✓			
1.93	±.03	1.936	✓			
.12	±.03	.150	✓			
.125	±.010	.126	✓			
.094	±.010	.095	✓			
3.00	±.030	3.00	✓			
.69	±.030	.682	✓			
.281	±.010	.280	✓			
.281	±.010	.280	✓			
.33	±.030	.324	✓			
.39	±.030	.383	✓			
.585	±.010	.585	✓			
1.170	±.010	1.169	✓			
∅.257	+ .006 - .001	.259	✓			
∅.063	+ .004 - .001	.064	✓			
.250	±.030	.242	✓			

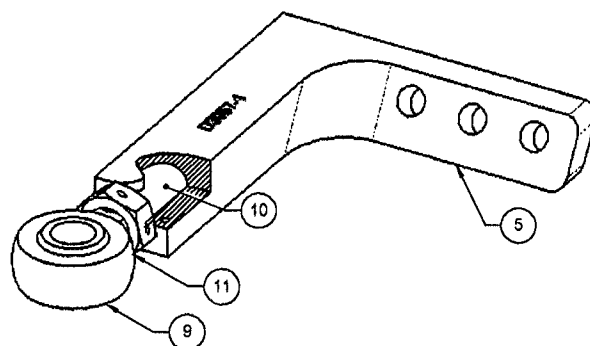
Measured by: <i>SB</i>
Date: 09/07/27

Audited by: <i>[Signature]</i>
Date: 09/07/28

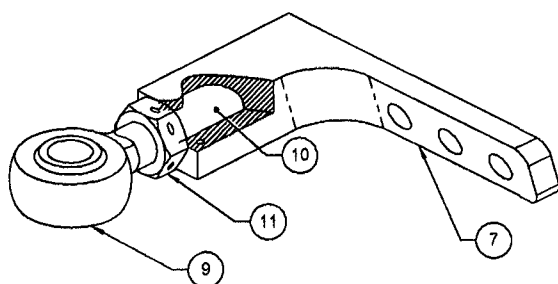
Prototype Approval: <i>RU</i> N/A
Date: 09/07/28 N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

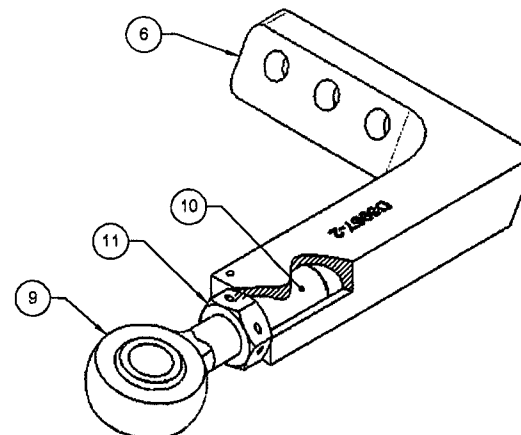
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1	X				D3957-041	HINGE ASSEMBLY, DOOR LH UPPER
2		X			D3957-042	HINGE ASSEMBLY, DOOR RH UPPER
3			X		D3957-043	HINGE ASSEMBLY, DOOR LH LOWER
4				X	D3957-044	HINGE ASSEMBLY, DOOR RH LOWER
5	1				D3957-1	HINGE, DOOR LH UPPER
6		1			D3957-2	HINGE, DOOR RH UPPER
7			1		D3957-3	HINGE, DOOR LH LOWER
8				1	D3957-4	HINGE, DOOR RH LOWER
9	1	1	1	1	D3815-3	ROD END
10	1	1	1	1	MS124738	HELICOIL, 3/8-24 UNF
11	1	1	1	1	NAS509-6	NUT



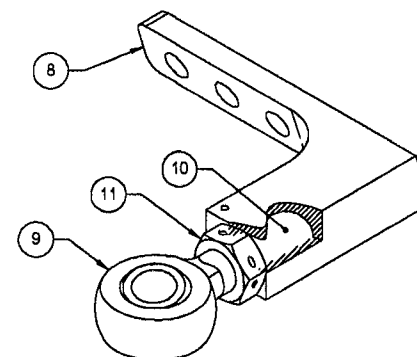
D3957-041 HINGE ASSY, DOOR LH UPPER



D3957-043 HINGE ASSY, DOOR LH LOWER



D3957-042 HINGE ASSY, DOOR RH UPPER



D3957-044 HINGE ASSY, DOOR RH LOWER

A	NEW ISSUE	BY	08.07.20
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.07.20		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

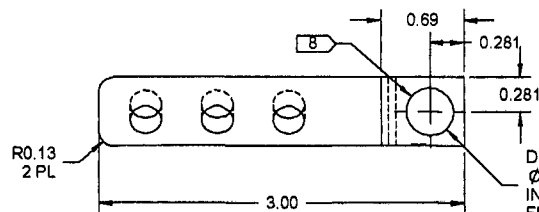
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SHEET 1 OF 5

TITLE **HINGE** SCALE
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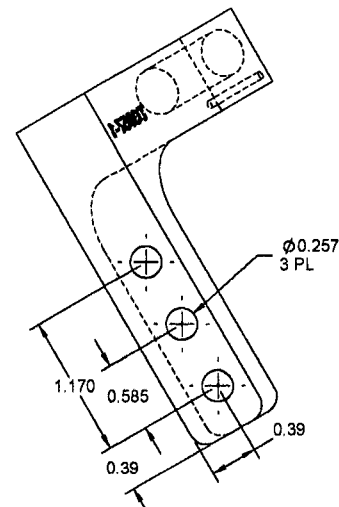
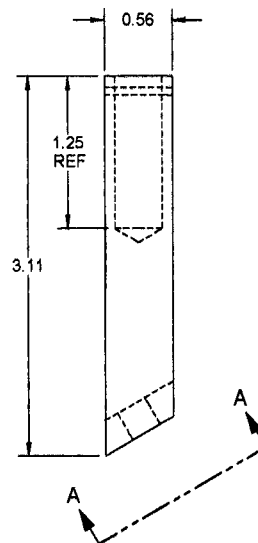
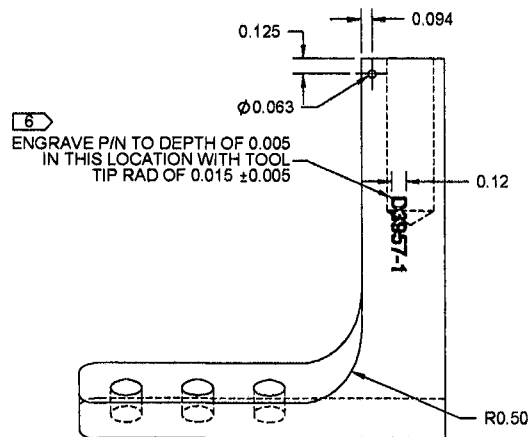
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PRELIMINARY ISSUE

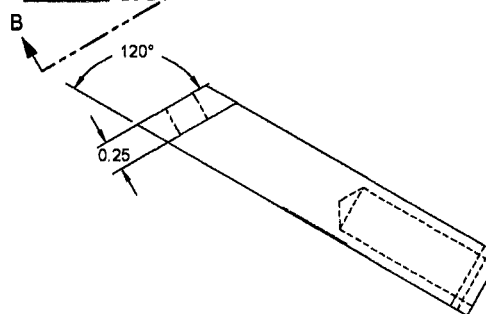
MP 09/10/14



DRILL AND TAP FOR 3/8-24 HELICAL INSERT
 $\phi 0.391$ X 1.25 DP
 INSTALL HELICOIL MS124738
 FLUSH WITH SURFACE



VIEW A-A B5-2



VIEW B-B C3-2

D3957-1 HINGE, DOOR LH UPPER

NOTES:

- 1) MATERIAL: 6061-T6 (6061-T651/T6510/T6511/T62) ALUMINUM BAR
 PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
 PER AMS-QQ-A-200/8 (OR AMS 4160)
 REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AS SHOWN
- 7) WEIGHT: 0.13 lbs
- 8) MASK HOLE PRIOR TO POWDER COAT

PRELIMINARY ISSUE

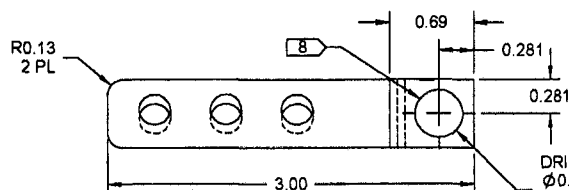
WPD 09/10/14

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DRAWN	AS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	PH	D3957	SHEET 2 OF 5
APPROVED	160	TITLE	SCALE
DE APPR.		HINGE	NTS
DATE	09.07.20	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
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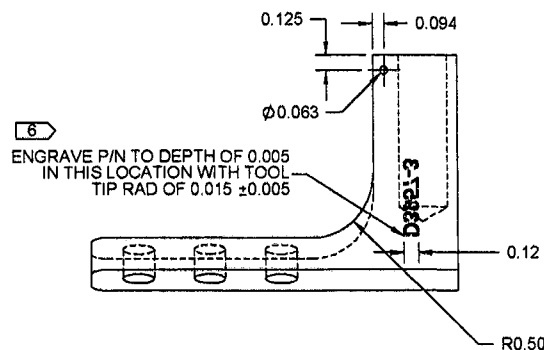
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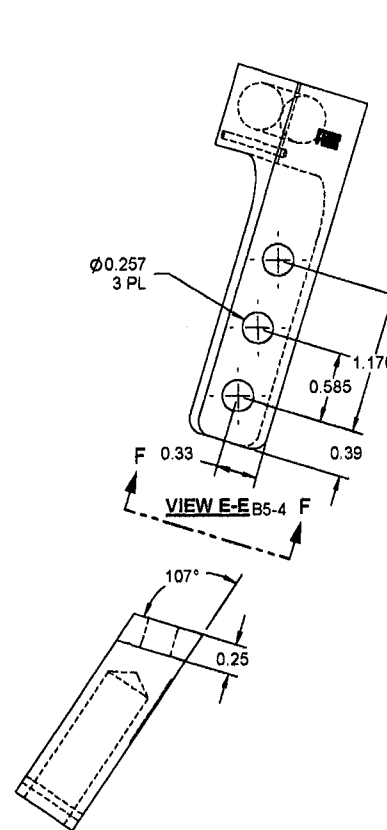
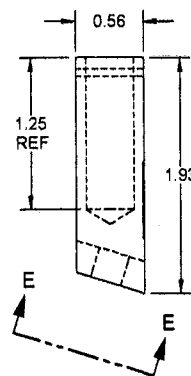
D



DRILL AND TAP FOR 3/8-24 HELICAL INSERT
 $\phi 0.391$ X 1.25 DP
 INSTALL HELICOIL MS124738
 FLUSH WITH SURFACE



ENGRAVE P/N TO DEPTH OF 0.005
 IN THIS LOCATION WITH TOOL
 TIP RAD OF 0.015 \pm 0.005



VIEW E-E B5-4

VIEW F-F C3-4

D3957-3 HINGE, DOOR LH LOWER

NOTES:

- 1) MATERIAL: 6061-T6 (6061-T651/T6510/T6511/T62) ALUMINUM BAR
 PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
 PER AMS-QQ-A-200/8 (OR AMS 4160)
 REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AS SHOWN
- 7) WEIGHT: 0.09 lbs
- 8) MASK HOLE PRIOR TO POWDER COAT

PRELIMINARY ISSUE

W. 9/10/14

DESIGN	<i>JS</i>	DART AEROSPACE LTD	
DRAWN	<i>JS</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>PH</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>PH</i>	D3957	SHEET 4 OF 5
APPROVED	<i>W</i>	TITLE	SCALE
DE APPR.		HINGE	NTS
DATE	09.07.20	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1

A

A

8 7 6 5 4 3 2 1

D

C

B

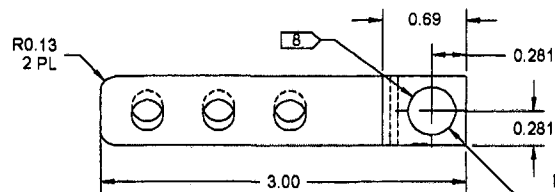
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D

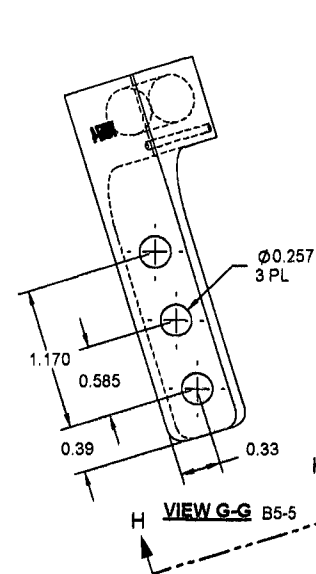
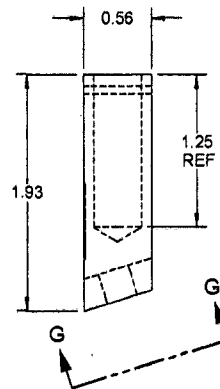
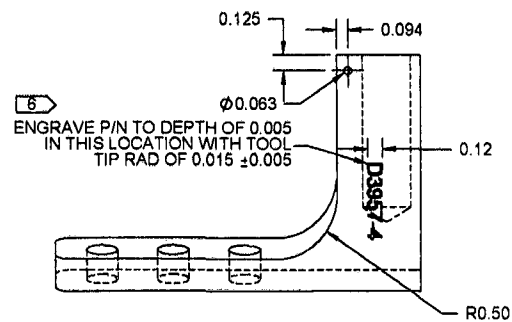
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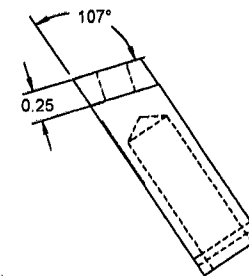
A



DRILL AND TAP FOR 3/8-24 HELICAL INSERT
 $\phi 0.391$ X 1.25 DP
 INSTALL HELICOIL MS124738
 FLUSH WITH SURFACE



VIEW G-G B5-5



VIEW H-H C3-5

D3957-4 HINGE, DOOR RH LOWER

NOTES:

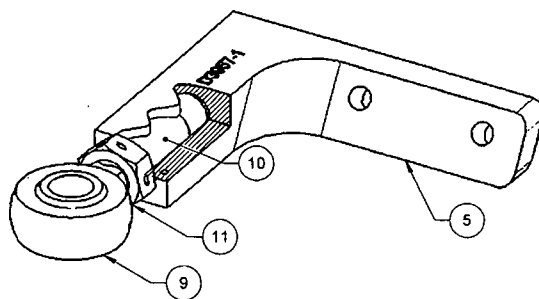
- 1) MATERIAL: 6061-T6 (6061-T651/T6510/T6511/T62) ALUMINUM BAR
 PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
 PER AMS-QQ-A-200/8 (OR AMS 4160)
 REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AS SHOWN
- 7) WEIGHT: 0.09 lbs
- 8) MASK HOLE PRIOR TO POWDER COAT

PRELIMINARY ISSUE
W 9/10/14

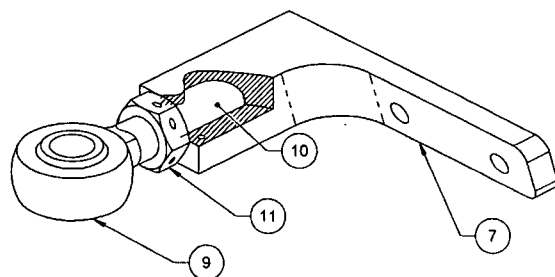
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DRAWN	05	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	21	D3957	SHEET 5 OF 5
APPROVED	10	TITLE	SCALE
DE APPR.		HINGE	NTS
DATE	09.07.20	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1

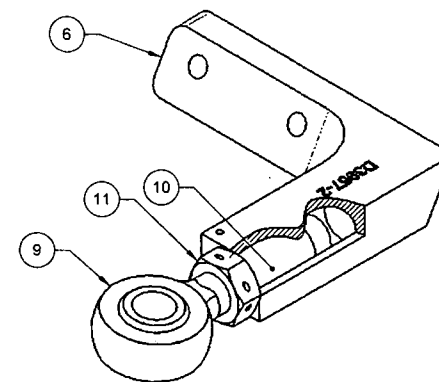
ITEM	QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
1	X				D3957-041	HINGE ASSEMBLY, DOOR LH UPPER
2		X			D3957-042	HINGE ASSEMBLY, DOOR RH UPPER
3			X		D3957-043	HINGE ASSEMBLY, DOOR LH LOWER
4				X	D3957-044	HINGE ASSEMBLY, DOOR RH LOWER
5	1				D3957-1	HINGE, DOOR LH UPPER
6		1			D3957-2	HINGE, DOOR RH UPPER
7			1		D3957-3	HINGE, DOOR LH LOWER
8				1	D3957-4	HINGE, DOOR RH LOWER
9	1	1	1	1	D3518-3	ROD END
10	1	1	1	1	MS124818	HELICOIL, 3/8-24 UNF
11	1	1	1	1	NAS509-6	NUT



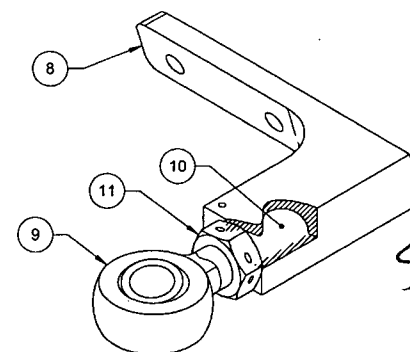
D3957-041 HINGE ASSY, DOOR LH UPPER



D3957-043 HINGE ASSY, DOOR LH LOWER



D3957-042 HINGE ASSY, DOOR RH UPPER

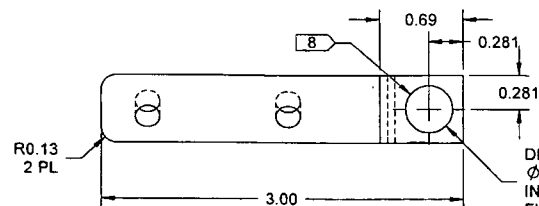


D3957-044 HINGE ASSY, DOOR RH LOWER

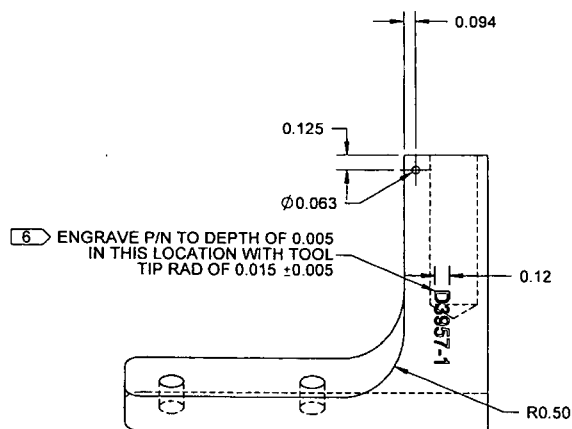
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2009-10-08
JMB

A	NEW ISSUE	09.09.03
REV.	DESCRIPTION	BY DATE
DESIGN		
DRAWN		
CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		
DATE	09.09.03	

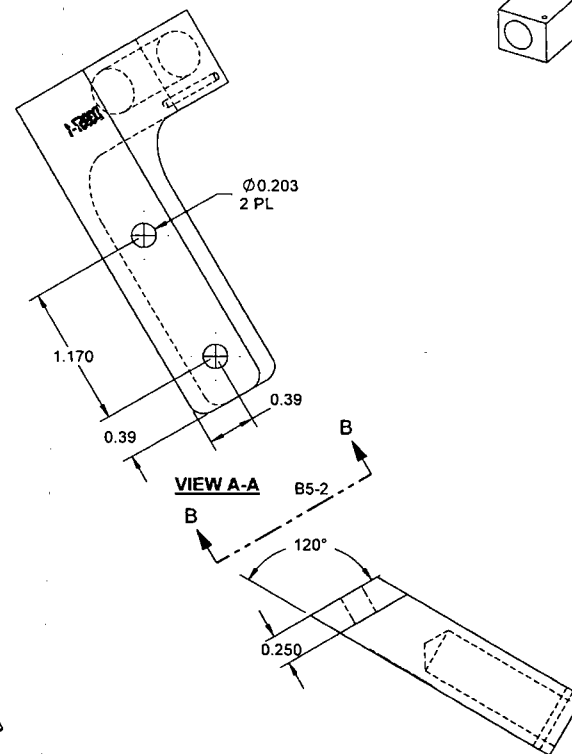
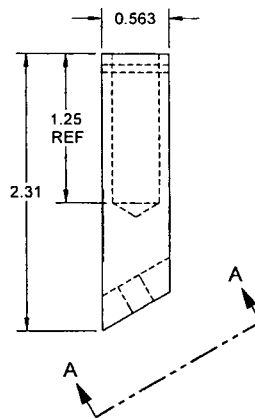
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3957	REV. A
TITLE HINGE	SCALE NTS
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DRILL AND TAP FOR 3/8-24 HELICAL INSERT
 $\varnothing 0.391 \times 1.25$ DP
 INSTALL HELICOIL MS124818
 FLUSH WITH SURFACE

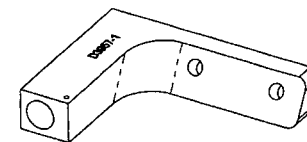


6 ENGRAVE P/N TO DEPTH OF 0.005
 IN THIS LOCATION WITH TOOL
 TIP RAD OF 0.015 ± 0.005



VIEW A-A

VIEW B-B



D3957-1 HINGE, DOOR LH UPPER

NOTES:

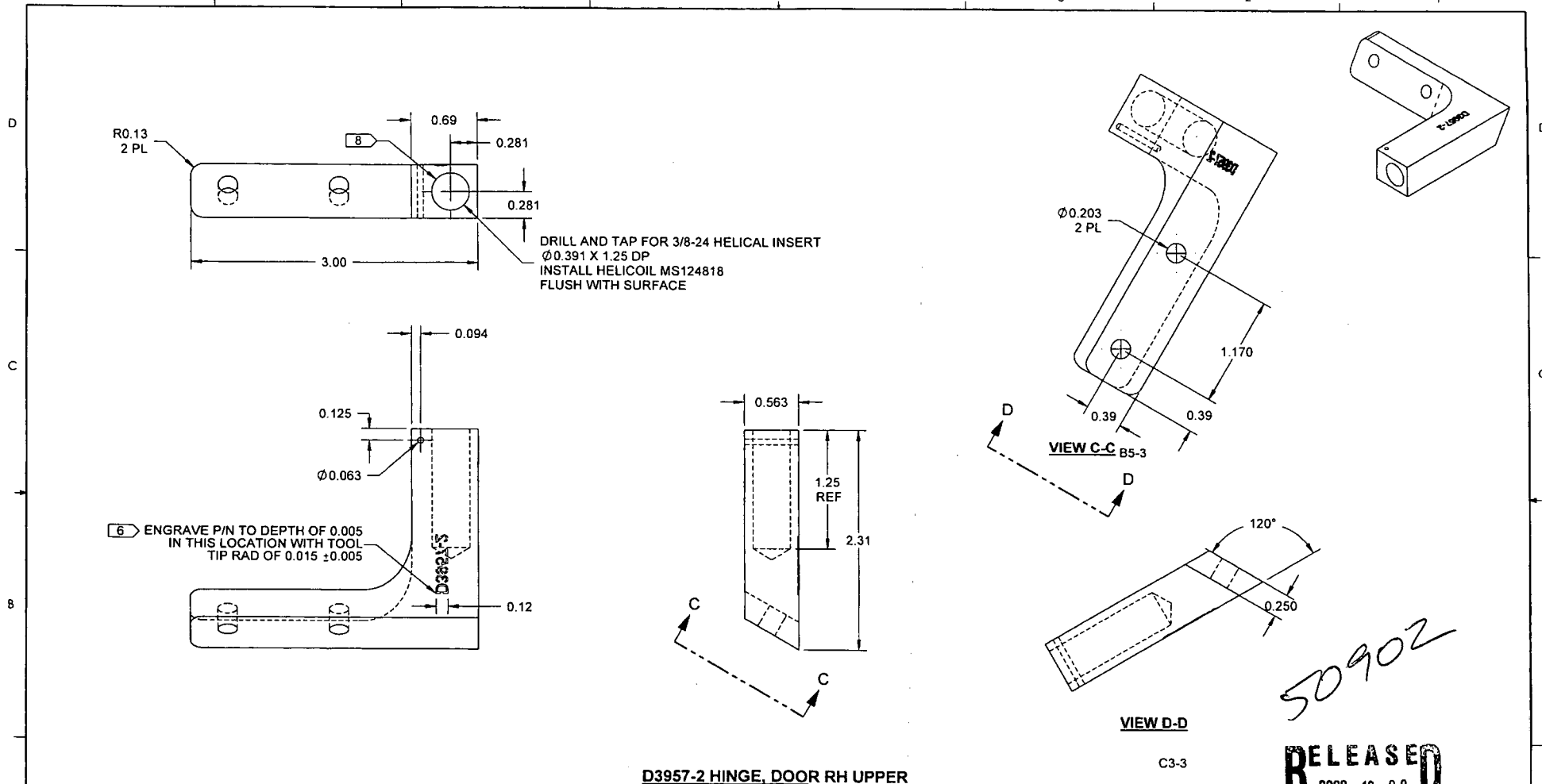
- 1) MATERIAL: 6061-T6 (6061-T651/T6510/T6511/T62) ALUMINUM BAR
 PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
 PER AMS-QQ-A-200/8 (OR AMS 4160)
 REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AS SHOWN
- 7) WEIGHT: 0.10 lbs
- 8) MASK HOLE PRIOR TO POWDER COAT

C3-2

RELEASED
 2009-10-08

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3957	SHEET 2 OF 5
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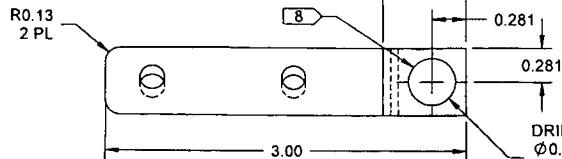
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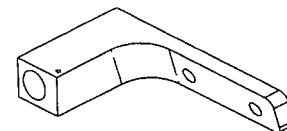
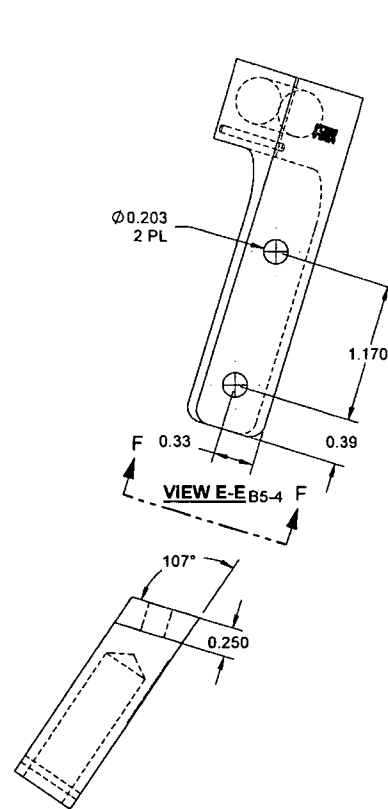
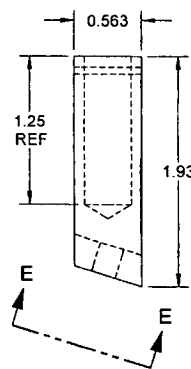
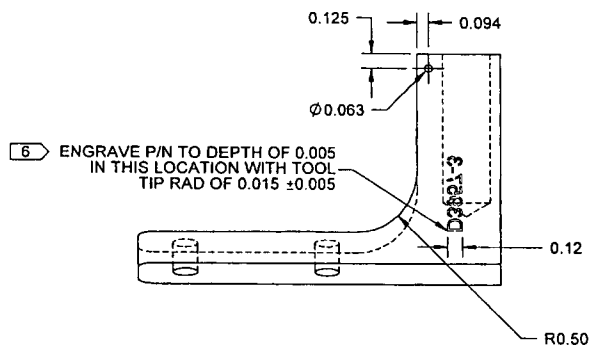
NOTES:

- 1) MATERIAL: 6061-T6 (6061-T651/T6510/T6511/T62) ALUMINUM BAR
 PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
 PER AMS-QQ-A-200/8 (OR AMS 4160)
 REF DART SPEC M6061T6B
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 POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AS SHOWN
- 7) WEIGHT: 0.10 lbs
- 8) MASK HOLE PRIOR TO POWDER COAT

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3957	SHEET 3 OF 5
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DRILL AND TAP FOR 3/8-24 HELICAL INSERT
 $\varnothing 0.391$ X 1.25 DP
 INSTALL HELICOIL MS124818
 FLUSH WITH SURFACE



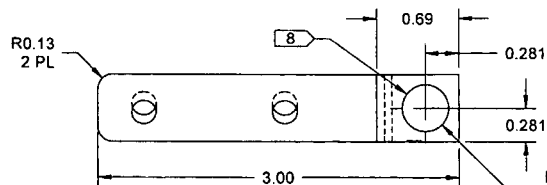
D3957-3 HINGE, DOOR LH LOWER

NOTES:

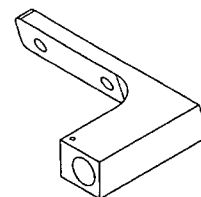
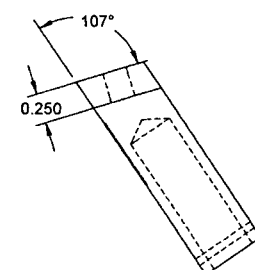
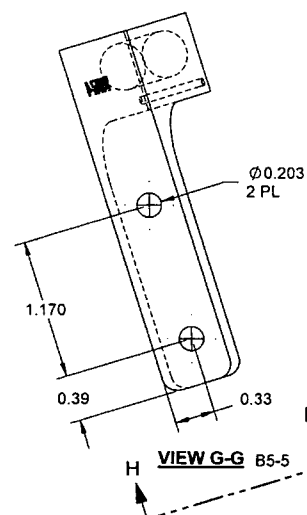
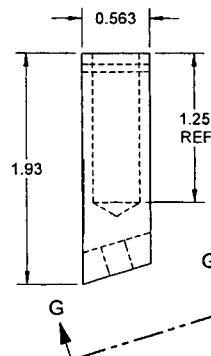
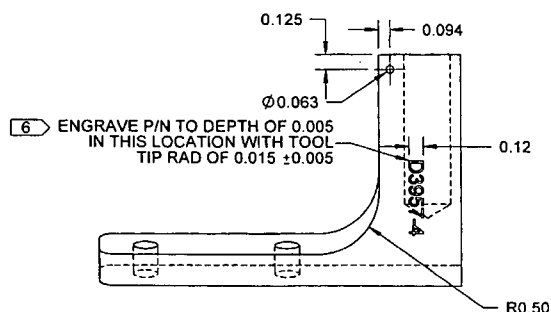
- 1) MATERIAL: 6061-T6 (6061-T6510/T6511/T62) ALUMINUM BAR
 PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
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 REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AS SHOWN
- 7) WEIGHT: 0.09 lbs
- 8) MASK HOLE PRIOR TO POWDER COAT

DESIGN		DART AEROSPACE LTD	
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50902
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DRILL AND TAP FOR 3/8-24 HELICAL INSERT
 $\varnothing 0.391$ X 1.25 DP
 INSTALL HELICOIL MS124818
 FLUSH WITH SURFACE



D3957-4 HINGE, DOOR RH LOWER

NOTES:

- 1) MATERIAL: 6061-T6 (6061-T651/T6510/T6511/T62) ALUMINUM BAR
 PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
 PER AMS-QQ-A-200/8 (OR AMS 4160)
 REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AS SHOWN
- 7) WEIGHT: 0.09 lbs
- 8) MASK HOLE PRIOR TO POWDER COAT

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